

Work Order ID 82598

82598

Page 1

April-03-12 11:27:32 AM

Item ID: D3463-041
 Revision ID:
 Item Name: Step Weldment Assembly
 Start Date: 03/04/2012 Start Qty: 4.00
 Required Date: 17/04/2012 Req'd Qty: 4.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 12/04/03 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3463	Rev B

100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3463 using DT8875								

(4) EL 12-4-16

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

4 Ø EL 12-04-16

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

S, 12/04/17

(x4)

LM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Stop ***NS2***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating MI 21134	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Mask areas indicated on dwg D3463 (holes, threads) START TIME: 3:30 OVEN TEMPERATURE: 400°F FINISH TIME: 4:00	0.00 0.00				4X	✓		M-L 12/04/17
140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 120920 Memo	0.00 0.00				4.	✓		BL 12-4-18.
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4X	✓		M-L 12/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3463-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 03/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 17/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>199</u>	0.00							
160									
Packaging	Memo	0.00				(40)			12/4/18
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/4/19

12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82598

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Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure
with wing walk DD 10.01.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806		Purchased	No			100	Each	132.0000	2	8			

238-806

SS DOWEL PIN 1" LONG

**

EL 12-4-13

Location	Loc Qty	Loc Code
ST399	32	
117606	32	
ST400	100	
120119	100	

D3453-3

Manufactured No

100 Each 16.0000 1 4

D3453-3

Clevis

**

EL 12-4-13

Location	Loc Qty	Loc Code
WA022	16	
78209	12	
80247	4	

D3453-5

Manufactured No

100 Each 11.0000 1 4

D3453-5

Plug

**

EL 12-4-13

Location	Loc Qty	Loc Code
WA	11	
59204	0	
78210	11	

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 82598

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Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

D3463-1 Manufactured No

100 Each 8.0000 1 4

D3463-1

Arm

**

EL 12-4-16

Location

Loc Qty

Loc Code

WA

8

78211

8

4

D3463-3 Manufactured No

100 Each 14.0000 1 4

D3463-3

Step

**

EL 12-4-16

Location

Loc Qty

Loc Code

78212 x 4

WA

14

78886

2

D3463-5 Manufactured No

100 Each 49.0000 2 8

D3463-5

End Cap

**

EL 12-4-13

Location

Loc Qty

Loc Code

WA004

19

78213

19

8

WA023

30

78838

30

D3463-7 Manufactured No

100 Each 10.0000 1 4

D3463-7

Drag Arm

**

EL 12-4-16

Location

Loc Qty

Loc Code

WA

10

78202 x 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

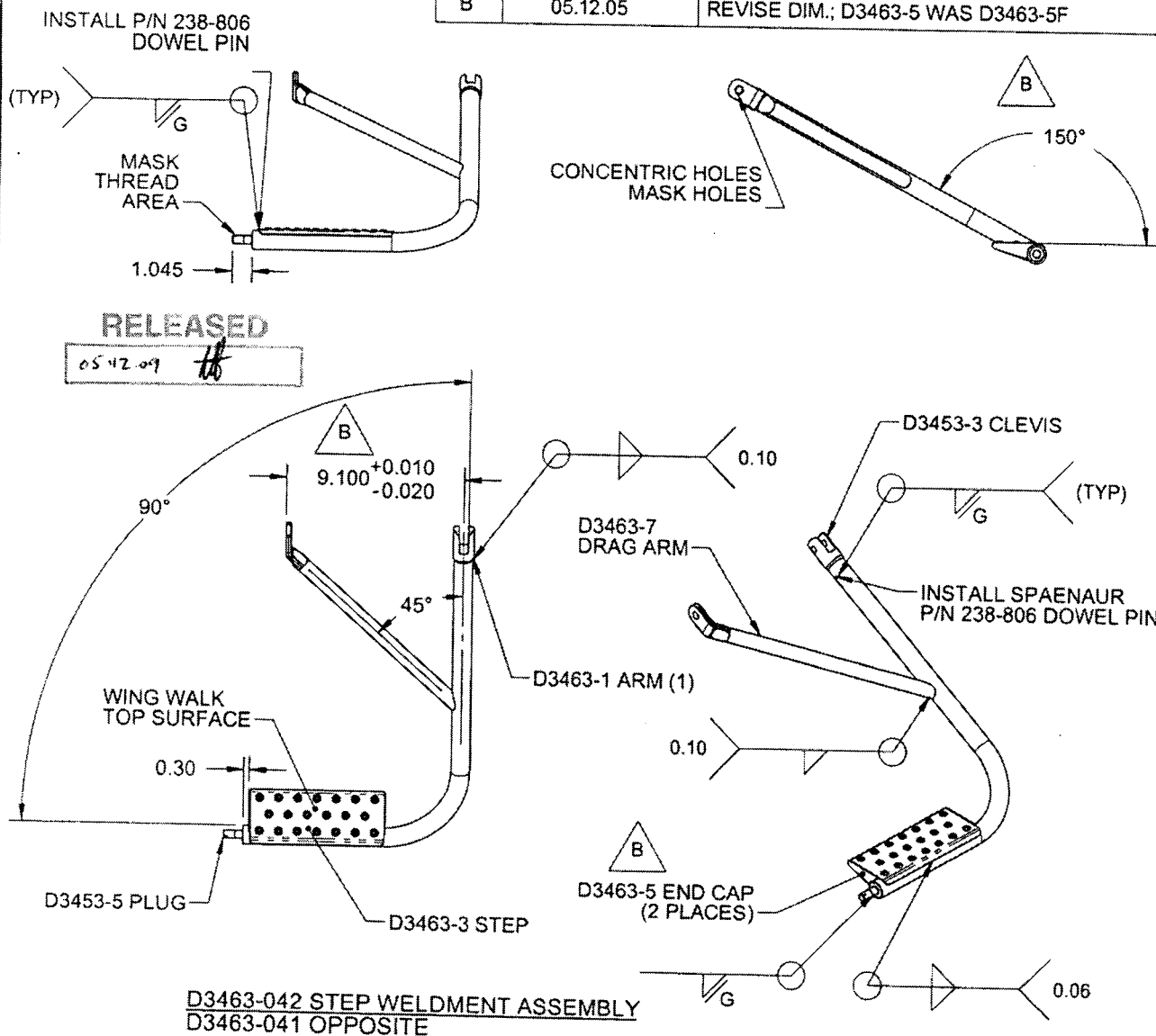
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE

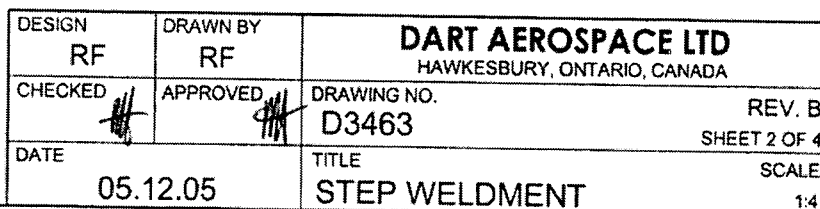
NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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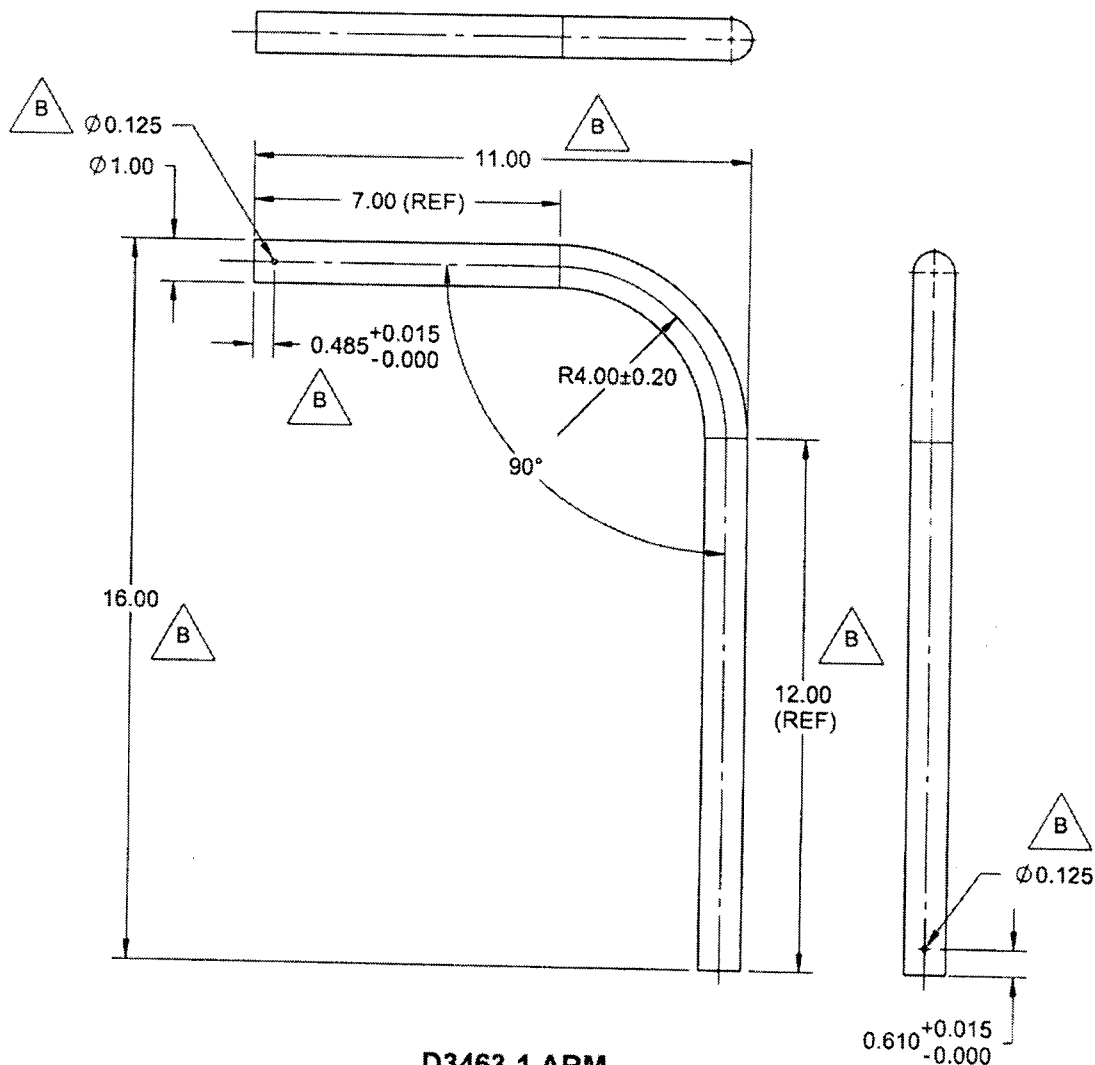
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SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82598 M45
12/04/05



RELEASED

05.12.09



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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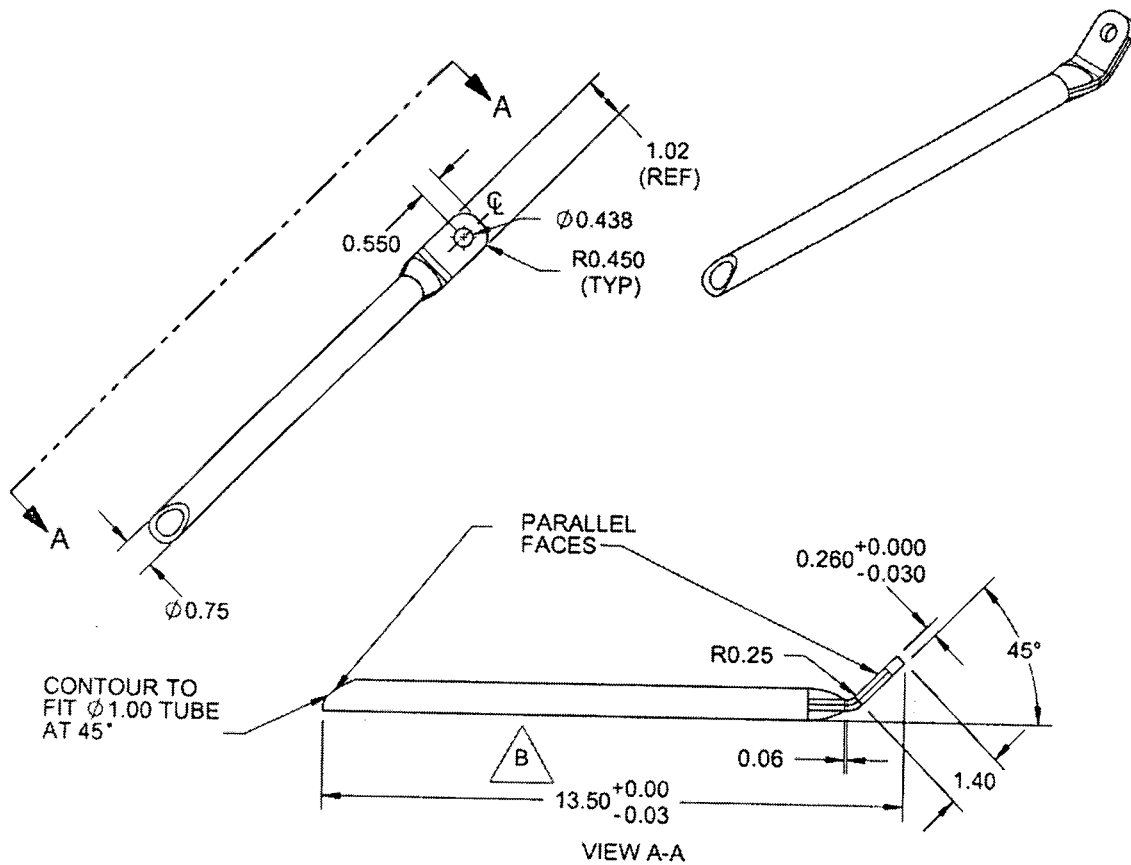
82578



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3463
DATE 05.12.05	TITLE STEP WELDMENT	REV. B SHEET 3 OF 4 SCALE 1:4

RELEASED

05.12.04



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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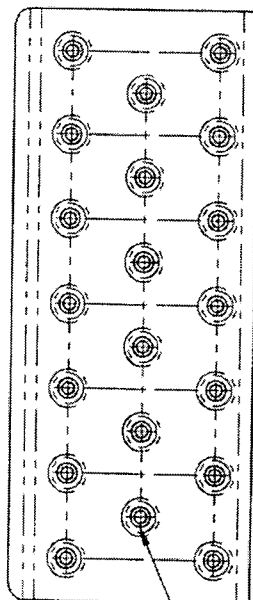
82598



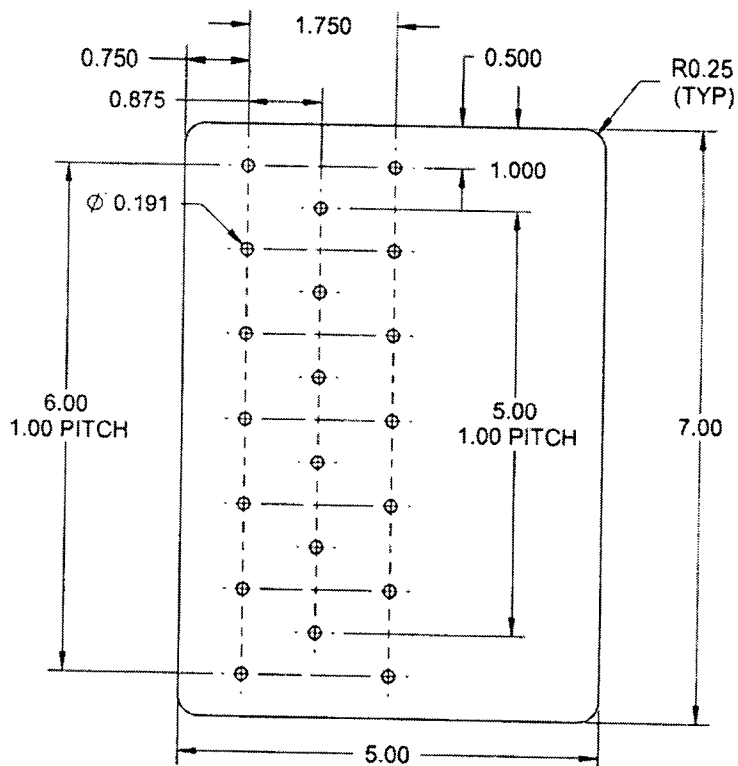
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED A	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

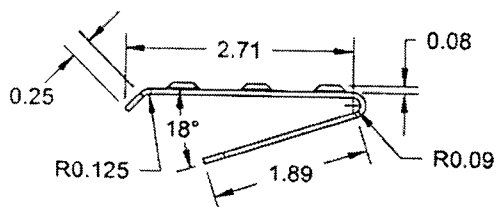
05.12.05 #



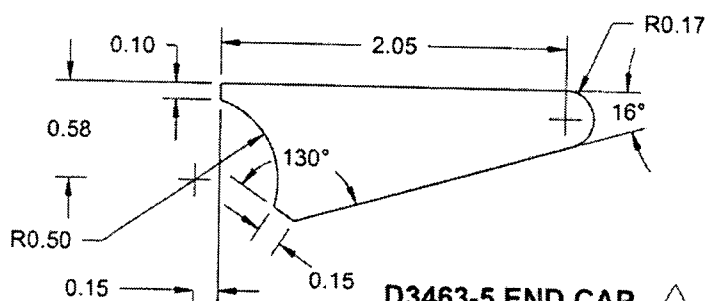
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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